

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015779**Date Inspected:** 23-Jul-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Xu Le Feng**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance(QA) Inspector, Baskar Govindarajan, was present during the times noted above for observations relative to the work being performed.

**Paint shop 2**

This QA inspector, Baskar Govindarajan, observed During the Quality Assurance Inspection of Façade plate, Approx. 105 mm length, cluster of porosity observed in weld no WD1- A 578-2, approx. 3mm deep and 3mm dia. Porosity observed in weld no. WD1- A 578- 20 and approx. 6 mm deep fusion discontinuity observed in weld no. WD1- A 578-1. The façade plate is now coated with primer (Interzinc 22). These weld repair locations has been taped for weld Repair after the coating work done. This QA Inspector wrote an Incident report on this issue. Please see the attaché photos for further details.

**Magnetic Particle Testing:**

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL-6028 MT report for this date. The member is identified as Façade plate connection plates of East, West, South and North tower of 53 mtr., 65 mtr. and 77 mtr. elevations in Heavy Dock Jetty. The weld designations reviewed are as follows:

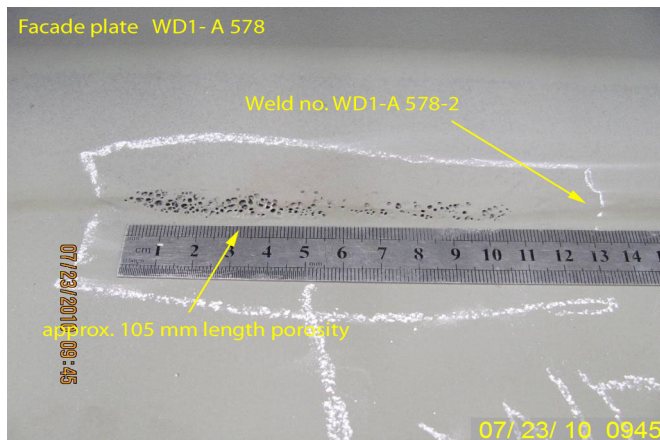
SSD1-SA 164 E/F- Jt. nos -35, 36, 43, 44 –South, Lift 2 Façade connection plate

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SSD1-SA 61 D/G- Jt. nos -9,10,11,12 –South, Lift 2 Façade connection plate  
ESD1-SA 298 D/G- Jt. nos -5,6,15,16 –East, Lift 2 Façade connection plate  
NSD1- SA 166 E/F – Jt. nos – 36,37,38,39,40,41,42,43 - North, Lift 2 Façade connection plate  
NSD1-SA 61 D/G –Jt. nos – 9,10,11,12 – North, Lift 2 Façade connection plate  
WSD1-SA 340 E/F –Jt. nos – 38,39,40,41 – West, Lift 2 Façade connection plate  
WSD1-SA 298 D/G –Jt. nos – 9,10,11,12 – West, Lift 2 Façade connection plate

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



## Summary of Conversations:

No relevant conversations.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Micheal Ng (15921845703), who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Baskar,Govindarajan	Quality Assurance Inspector
<b>Reviewed By:</b>	Clifford,William	QA Reviewer

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